

Work Order ID 70726

Tuesday, June 14, 2011 7:40:56 AM

Page 1

Item ID: D2012-111

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 6/13/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2012-111

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2012-111

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-6-14

24

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-6-14

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8 u/06/14

Locator
724

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Item ID: D2012-111

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 6/13/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Packaging	Identify as per dwg & Stock Location: <u>4</u>	0.00							
Packaging	Memo	0.00							

Handwritten: 6/14/15 24

Handwritten: 6/14/15 24



Handwritten: 6/14/15 24


Work Order ID 70726

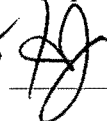
Page 3

Tuesday, June 14, 2011 7:40:56 AM

Item ID: D2012-111 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bracket
Start Date: 6/13/2011 Start Qty: 12.00  Cust Item ID:
Required Date: 6/15/2011 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

n/6/15 
11-06-15
24

Picklist Print

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Work Order ID: 70726



Parent Item: D2012-111



Parent Item Name: Bracket

Start Date: 6/13/2011

Required Date: 6/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C000.05.020Now laser cut0EC
IPP D 07.01.24 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

119.1000

0.0215

0.271579

1.



B11-6-14

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

119.1

117275

4.3

117653

114.8

117275

24

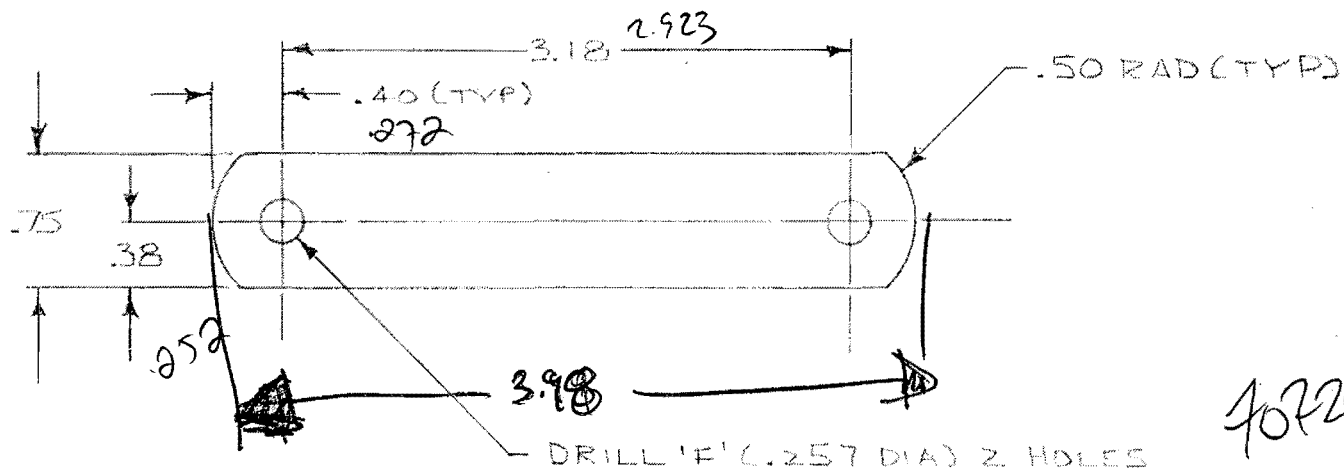
70726

1

Prototype

Prototype Approval:	N/A
Date:	N/A

A



NOTES: 1. MAT'L AISI 304/316 CRCS
.063 THICK



REVISION FROM D2012-111-102	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	4/4	DRAWN		BASIC CODE	DR. DASH NO.	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
	4/4	APPROVED		DR-DIMPLE	DR. DASH NO.	DATE		DRAWN HATTON 06/03/12 DESIGN BRADLEY 06/03/12 CHECKED BRADLEY 06/03/12 CLIENT		
	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER UNF 1-7222 5. HOLES PER AND 10387			LIMITS 1. TOLERANCES — .XX ± .030 2. ANGLES 2. 90° 3. PARALLELISM 4. .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL HAVE CENTRAL LINES .005	BASIC CODES B2-M520470AD B2-M520470AD		TITLE BRACKET		CODE D2012-111	
REPORT ALL DISCREPANCIES — DO NOT SCALE										

D2012-111